

**Work Order ID 67132**

Wednesday, March 09, 2011 9:54:34 AM



Page 1

Item ID: D3507-1-BENT

Accept



Setup Start



Revision ID:

Item Name: Skidtube Assembly EC135

5  
DP

Stop



Start Date: 3/9/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/03/10 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3507	Rev C	

120



BENDING MACHINE - SKIDTUBES

CNC Bend 1

CNC Delta 100 Bender

Memo 0.00

1- Bend tube as per program on CNC Bender and Dwg D3507, use DT9632 bending aide

2- Cut FWD END of tube as per dwg D3507

SAD/DP 11-03-10

5

PTC

40



QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo 0.00

5 Ø Ben/03/10

300



Identify as per dwg &amp; Stock Location: LG 0.00

Packaging

Memo 0.00

5 Ø Ben/03/10

Packaging

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod-Mgr	Approval QC Inspector

11-03-10-011

Part No: D3507-1-BENT PAR #: \_\_\_\_\_ Fault Category: Skid tube NCR: Yes No DQA: / Date: 11-03-15  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: / Date: 11-03-15

NCR: 67132		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-3-10	120	DENT FOUND AFTER BENDING  PC: process (material skipping)	CP 11-03-10 051042	SCRAP Replace B# 28622 X1	DP 11-3-10	BE 11-03-11	CP 11-03-10 051042	S WOSM

NOTE: Date &amp; initial all entries

**Work Order ID 67132**

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Wednesday, March 09, 2011 9:54:34 AM

Item ID: D3507-1-BENT

Accept



Setup

Start



Revision ID:

Item Name: Skidtube Assembly EC135

Stop



Start Date: 3/9/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
Description

310



QC21- Final Inspection - Work Order Release

QC

Quality Control

M<sup>emo</sup>Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

1/3/n J

MF  
11-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, March 09, 2011 9:54:31 AM

Page 1

Work Order ID: 67132



Parent Item: D3507-1-BENT



Parent Item Name: Skidtube Assembly EC135

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.09.17 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2962-150 		Manufactured	No			100	Each	91.0000	1	2			

3.540 Outer Tube, Extrut

Location	Loc Qty	Loc Code
HALL	91	
	18	
	73	

28672  
59934

(3) 11-3-10

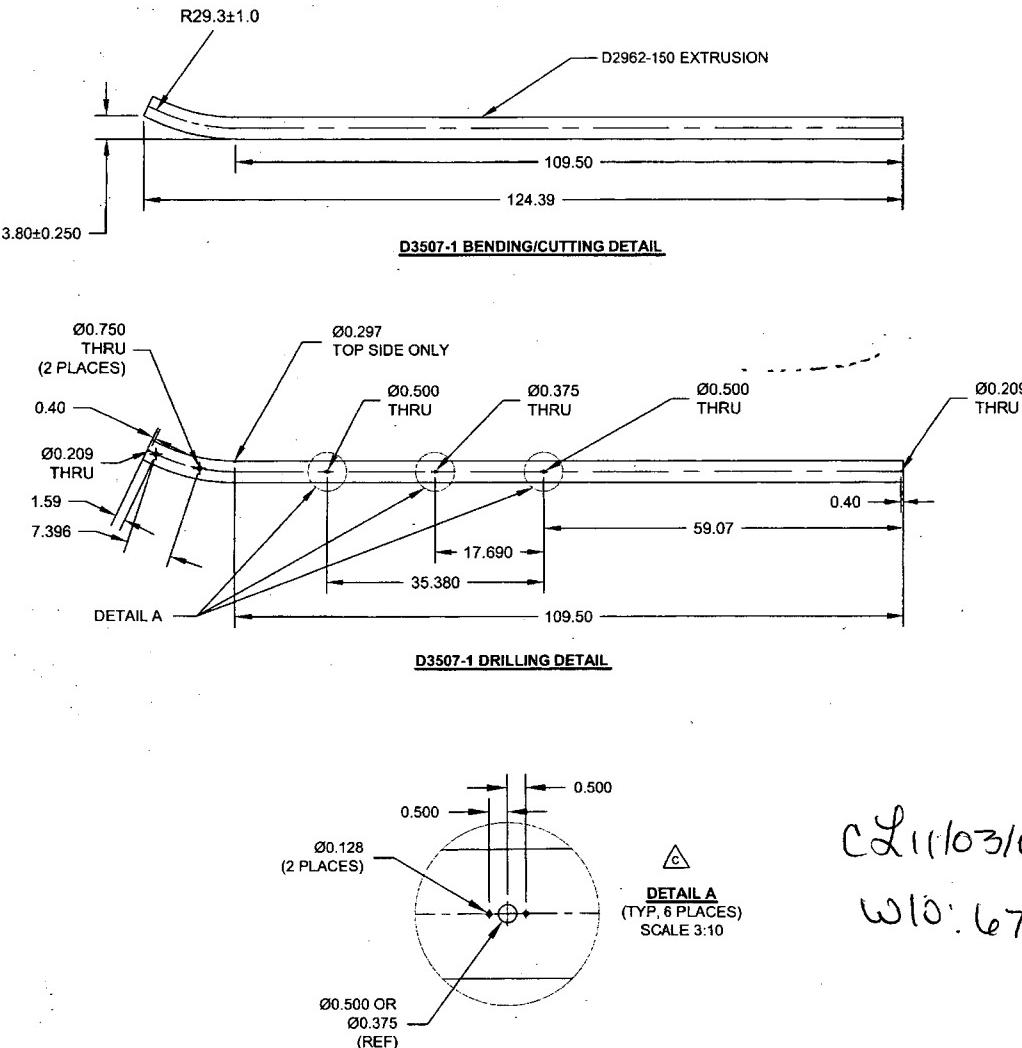
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>Qty</b>	<b>Part Number</b>	<b>Description</b>
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3604-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

#### **GENERAL NOTES**

- 1) FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING  
D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER  
DART QSI 005 4.4

2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED

4) WELDING TO BE DONE PER DART QSI 004

5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND  
WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241-291 ADHESIVE PER  
DART QSI 015 AFTER BENDING

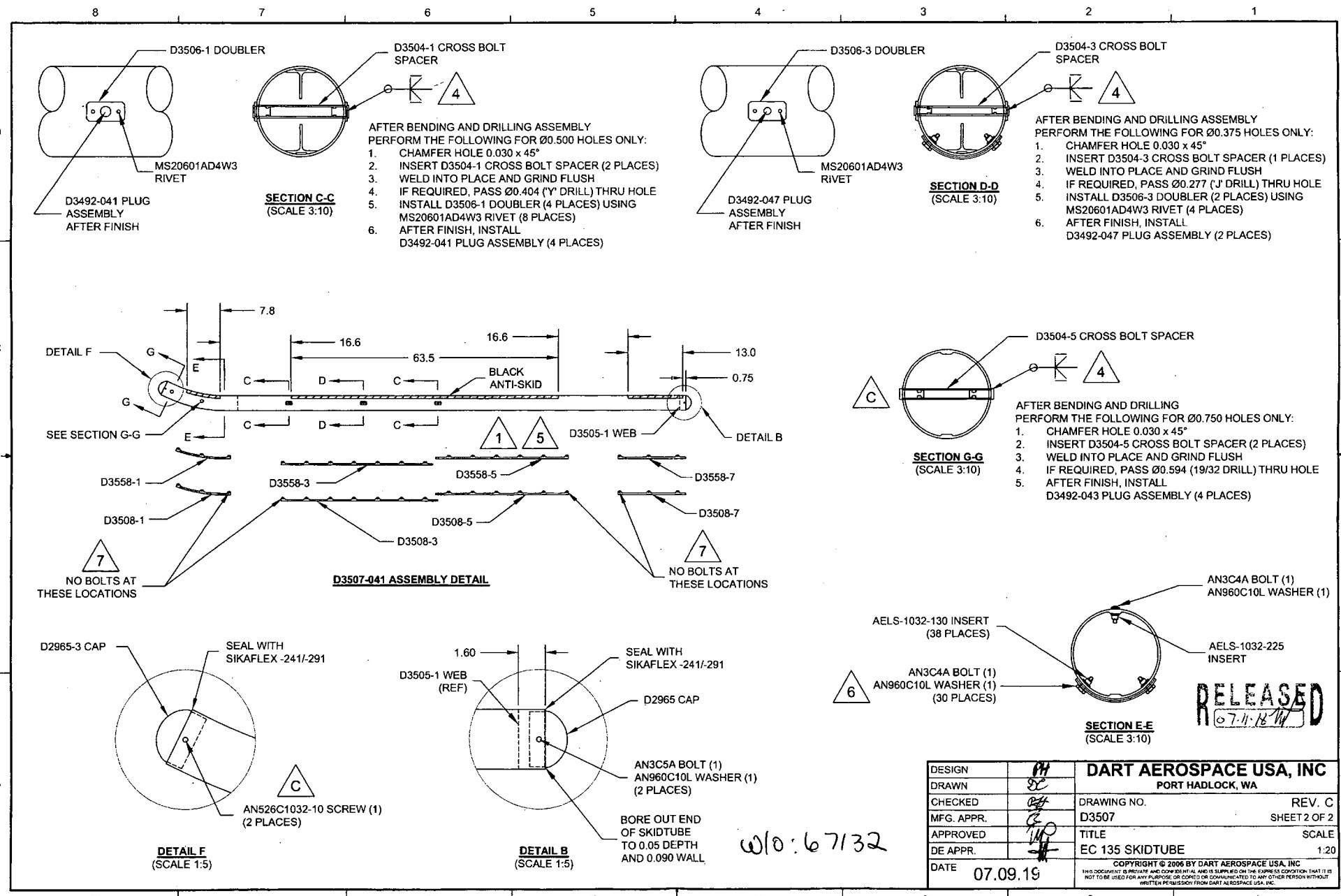
6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38  
PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38  
PLACES) AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241-291.

7) DO NOT INSTALL AN3C4 BOLTS AND AN960C10L WASHERS IN INDICATED  
LOCATIONS

CL11103/09

W10:6713-

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	<b>DART AEROSPACE USA, INC</b>	
DRAWN	<i>JTC</i>	PORT HADLOCK, WA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>EZ</i>	D3507	SHEET1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	EC 135 SKIDTUBE	NTS
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CHECKED	<u>BB</u>	DRAWING NO.	REV. C	
MFG. APPR.	<u>CE</u>	D3507	SHEET 2 OF 2	
APPROVED	<u>MM</u>	TITLE	SCALE	
DE APPR.	<u> </u>	EC 135 SKIDTUBE	1:20	
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